

Work Order ID 70613

Monday, June 13, 2011 12:33:40 PM



Page 1

Item ID: D3307-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *11-06-13*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3307	Rev A

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet
304 .032

Memo

0.00

*B11-7-5**(4)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B11-7-5

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

*81107106**+4*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Brake NC

Memo

0.00

Brake NC

bend as per dwg D3307

140



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Bond gasket as per dwg D3307

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/11/07/06

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160

Operation
DescriptionIdentify as per dwg & Stock Location: 232-A

Packaging

Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

Memo

0.00

Memo

0.00

11/7/08 (4) S

11/7/08 (4) S

MF 11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 12:33:46 PM

Page 1

Work Order ID: 70613



Parent Item: D3307-041



Parent Item Name: Access Panel Assembly

Start Date: 6/10/2011

Required Date: 6/22/2011

Comments: IPP: A 08.08.05 New issue EC verified by: DD

Start Qty: 4.00

Required Qty: 4.00

Start Qty: 4.00

Required Qty: 4.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70613
Description: Panel	Part Number:	D3307-1
Inspection Dwg: D3307 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-7-15	Date:	11-7-16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.12	New Issue	P/O D3307-041	KJ/DD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

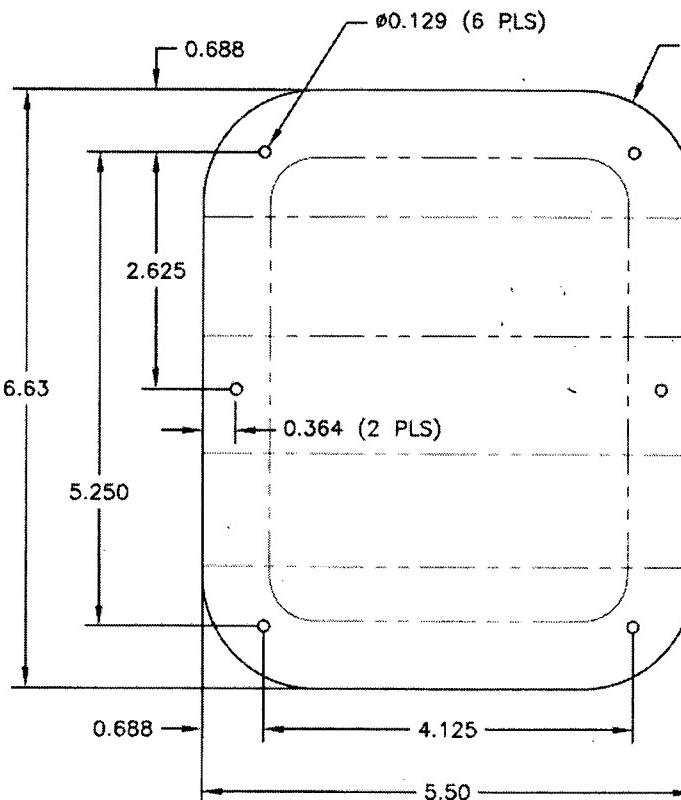
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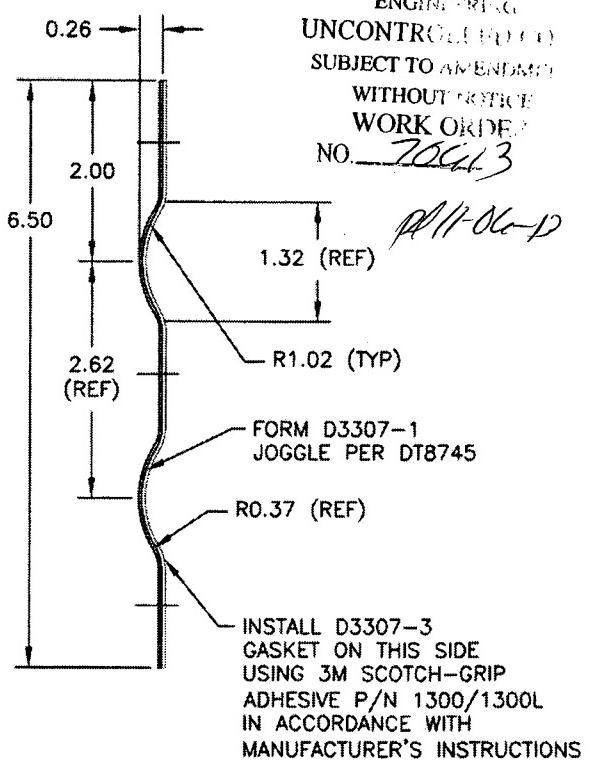


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED /	APPROVED	DRAWING NO.	REV. A
		D3307	SHEET 1 OF 2
DATE		TITLE	SCALE
04.09.23		ACCESS PANEL ASSEMBLY	1:2
A	04.09.23	NEW ISSUE	

RELEASED
05.01.18



D3307-1 PANEL FLAT PATTERN



D3307-041 BEND DETAIL
IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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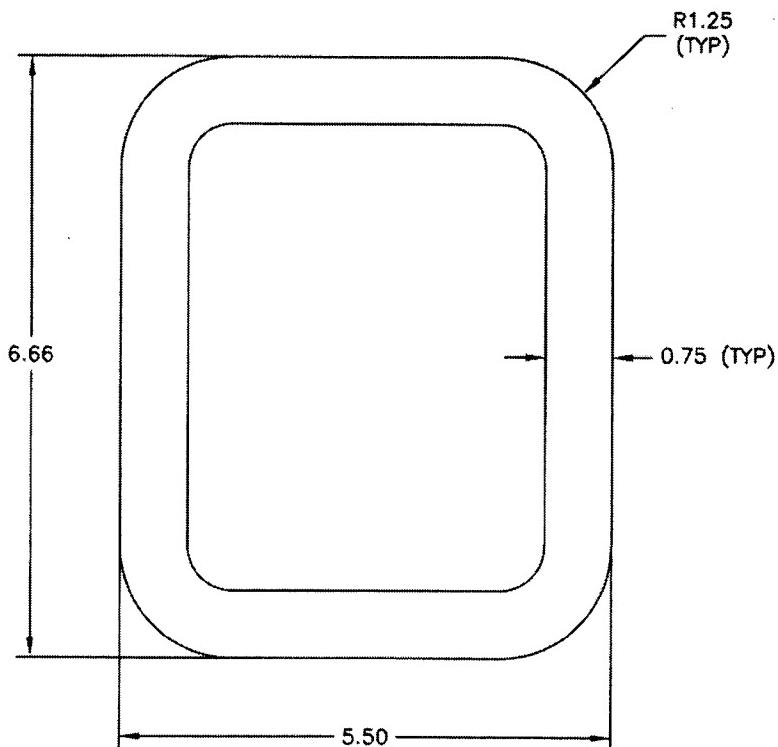
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED
05.01.18 *[Signature]*

W/0 70013



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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